

slip Oct. 25

Work Order ID 91377

\*91377\*

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October-05-12 11:31:42 AM

Item ID: D4419-3 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Aft Support Plate  
 Start Date: 10/05/12 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 10/12/12 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: ML5 Date: 12-10-05 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4419	A								
100		0.00							
*100*									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
34. (73)	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
*110*									
QC	Memo	0.00							
Quality Control									

(4)

B12-10-11

(4)

B12-10-11

PTC →

NCR: ☒ Yes ☐ No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: SWH Date: 12/10/22QA Closed: CK Date: 12/10/22

Work Order: <u>91377</u> Part No. <u>D4419-3</u> NCR No. <u>12-1942</u>				<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b> <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input checked="" type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input checked="" type="checkbox"/> Equip/Tooling <input checked="" type="checkbox"/> Operator <input type="checkbox"/> Material <input type="checkbox"/> Setup <input type="checkbox"/> Other <input type="checkbox"/> Process <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Unapproved <input type="checkbox"/>	12-10-16	100	2	part scrap because dimension should be at .375 and throw are at .328 out of dimension Parts shifted on table on water jet.	DAS 16 257042 12/10/16	part scrap and destroyed replace by B# 122521 Q7 x 2 \$13.14 x 2 = 26.28	12-10-12	SMB 12-10-16	DAS 16 257042 12/10/16		
<b>FAULT CATEGORY</b>											
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input checked="" type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input checked="" type="checkbox"/> Other		



# Picklist Print

October-05-12 11:31:41 AM

Page 1

Work Order ID: 91377

Parent Item: D4419-3

Parent Item Name: Aft Support Plate

Start Date: 10/05/12

Required Date: 10/12/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased	No				sf	194.0000		1.455158	1.5	10-12-11	

Location

Loc Qty

Loc Code

MAT020

194

122521

194

122521

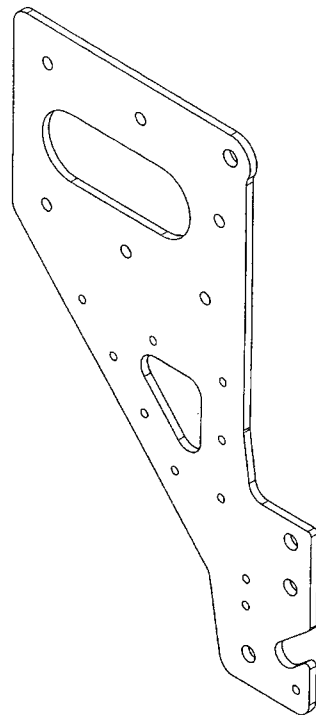
(4)

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	91377
<b>Description: Aft Support Plate</b>		<b>Part Number:</b>	D4419-3
<b>Inspection Dwg: D4419</b>	<b>Rev: A</b>	<b>Page 1 of 2</b>	

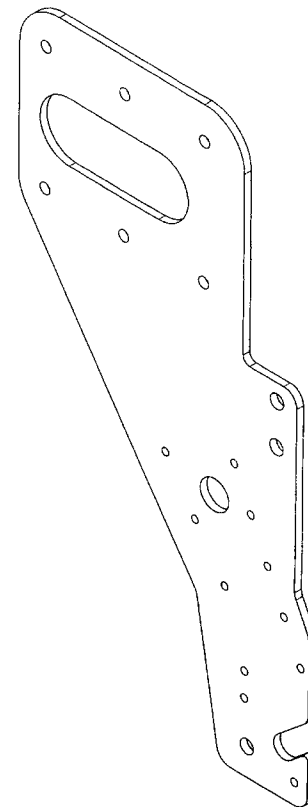
### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.130	2		V BOZ	
Ø0.191	+0.005/-0.001	.193	2		V	
Ø0.250	+0.005/-0.001	.250	2		V	
Ø0.53	+0.008/-0.001	.530	2		V	
5.55	+/-0.030	5.568	2		V	
5.27	+/-0.030	5.290	2		V	
4.25	+/-0.030	4.269	2		V	
2.80	+/-0.030	2.803	2		V	
0.40	+/-0.030	.409	2		V	
3.83	+/-0.030	3.834	2		V	
5.56	+/-0.030	5.566	2		V	
6.26	+/-0.030	6.262	2		V	
7.14	+/-0.030	7.14	2		V	
7.73	+/-0.030	7.73	2		V	
0.31	+/-0.030	.307	2		V	
0.38	+/-0.030	.380	2		V	
0.750	+/-0.010	.750	2		V	
1.53	+/-0.030	1.533	2		V	
0.390	+/-0.010	.388	2		V	
0.450	+/-0.010	.450	2		V	
1.67	+/-0.030	1.666	2		V	
10.55	+/-0.030	10.570	2		Prover	
8.00	+/-0.030	8.00	2		V	
6.02	+/-0.030	6.042	2		V	
1.10	+/-0.030	1.090	2		V	
1.20	+/-0.030	1.209	2		V	
0.50	+/-0.030	.502	2		V	
1.500	+/-0.010	1.497	2		V	
0.60	+/-0.030	.603	2		V	
2.300	+/-0.010	2.297	2		V	
0.63	+/-0.030	.640	2		V	
0.991	+/-0.010	.994	2		V	
0.440	+/-0.010	.444	2		V	





**D4419-1 FWD SUPPORT PLATE**



**D4419-3 AFT SUPPORT PLATE**

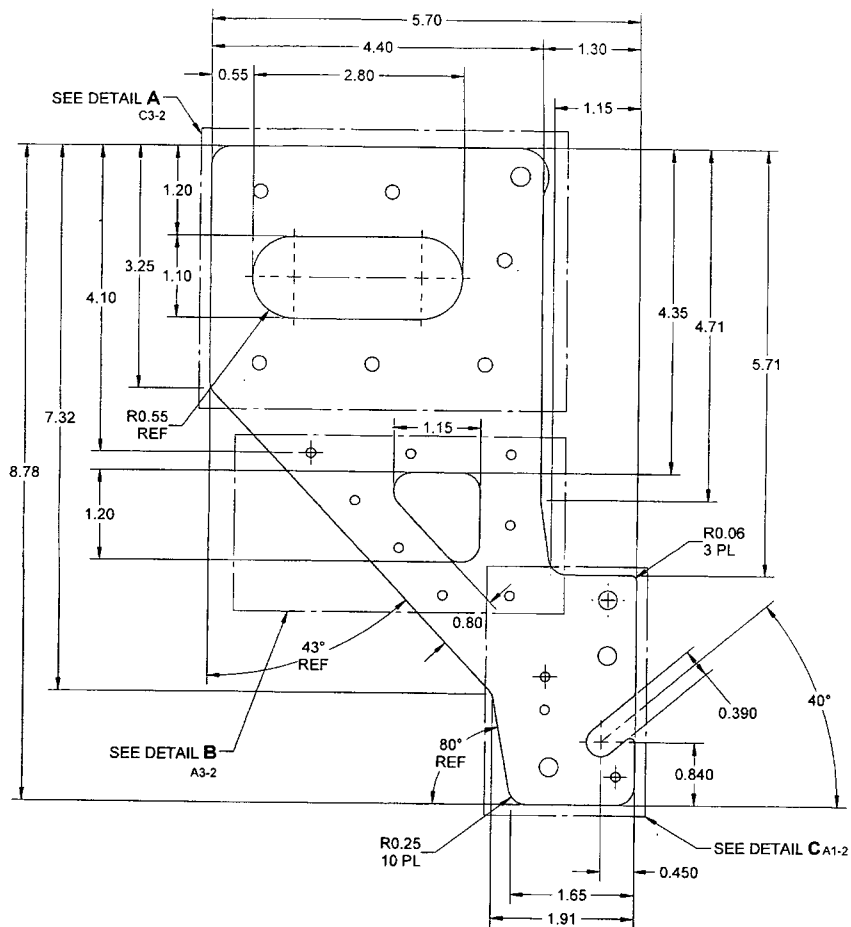
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 91377 MLS  
12-10-05

**RELEASED**  
2011-07-28  
JW

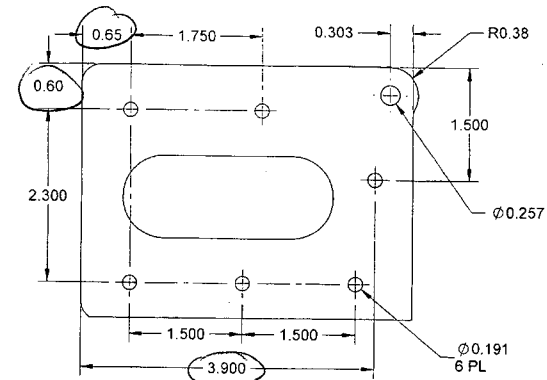
**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -1: 0.88 lbs  
-3: 1.10 lbs

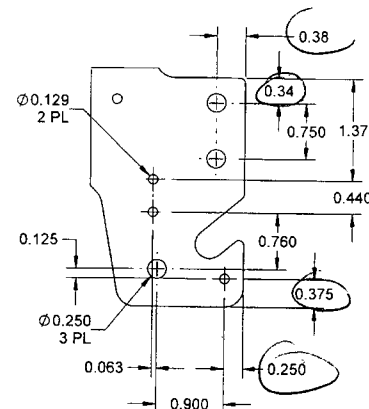
A		NEW ISSUE		AJS	11.07.06
REV.		DESCRIPTION		BY	DATE
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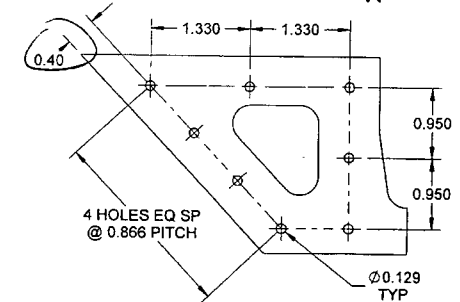
**D4419-1 FWD SUPPORT PLATE**



**DETAIL A D8-2**



**DETAIL B B7-2**



**DETAIL C A4-2**

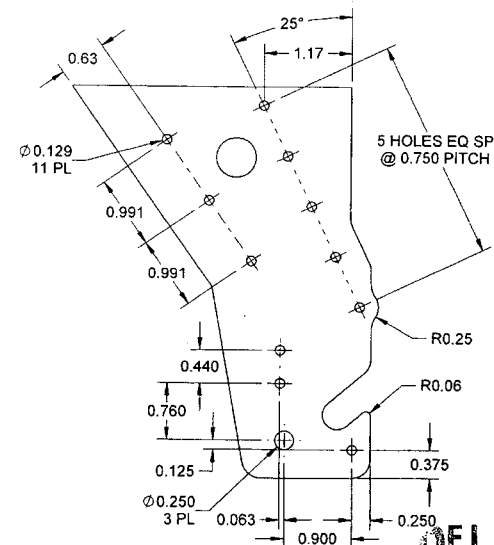
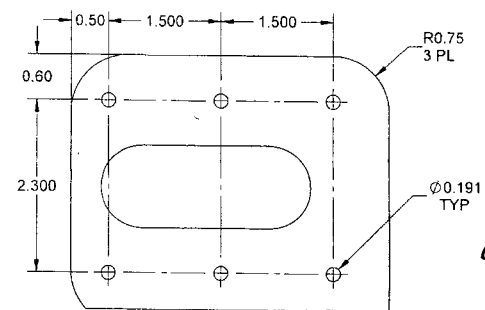
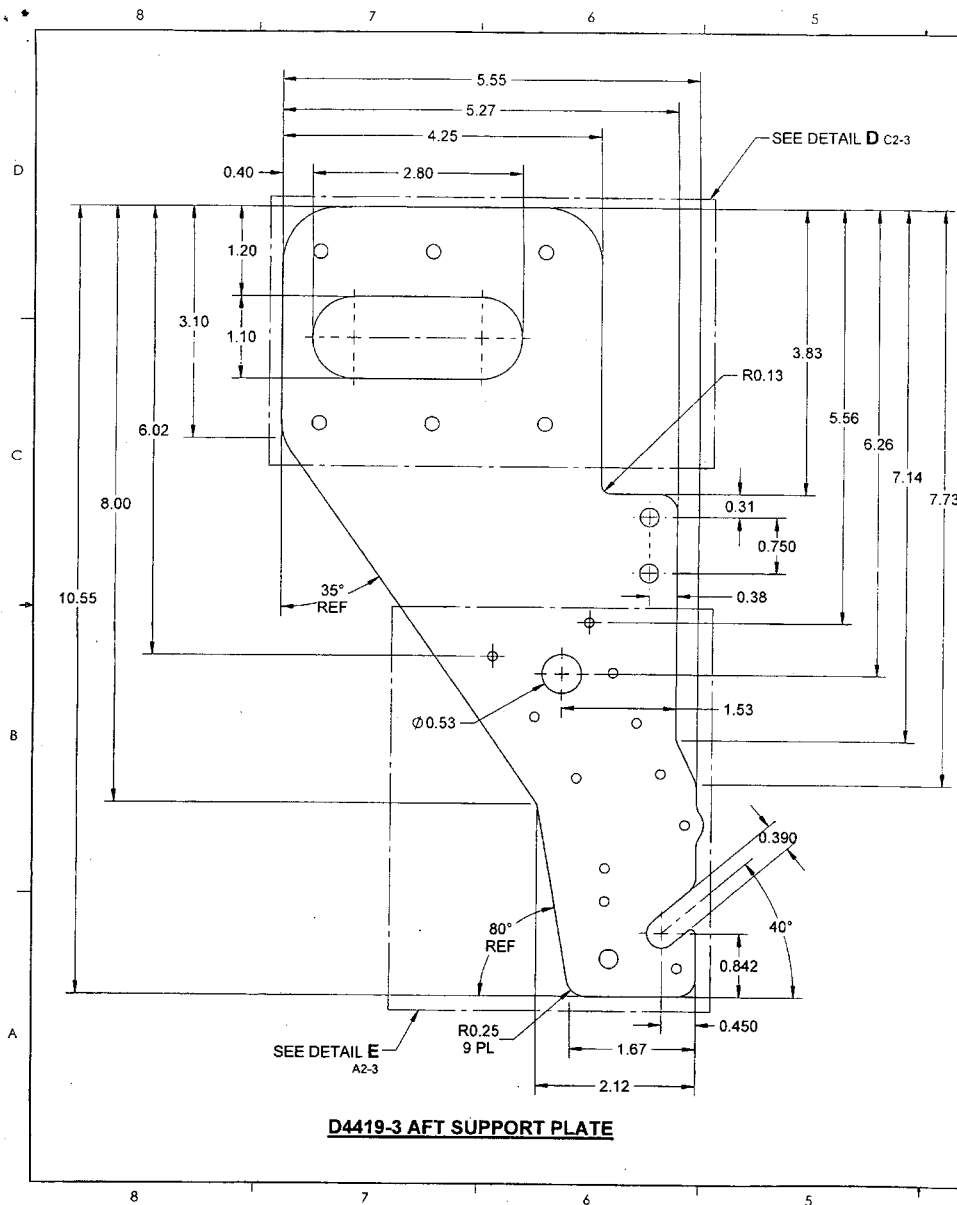
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2011-07-28

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